D350-56[redacted]111B DSI

LEVEL	QTY	P/N	DRAWING REV	PART DESCREPTION	WORK ORDER # (BATCH #)	FINDINGS
	X	D3294-1B	PD1	BRACKET ASSEMBLY BLANK	B93450	PART IS AS PER DRAWING
						NO FLAWS
1	1	D3294-3B	PD1	BRACKET	B93450	ALL MATERIAL CERT'S AND FAI'S ARE ATTACHED
2	1	D3295-5	REV C	DOUBLER	B76993	
3	15	MS20770AD4-5	N/A	RIVET	M122452	

Ship Friday 16/11

PRELIMINARY ISSUE

Work Order ID 93450

93450

November-15-12 8:37:10 AM

Item ID: D3294-1B **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: ~~PRELIM~~ **Stop** *NS2*

Item Name: Bracket, Blank

Start Date: 11/15/12 **Start Qty:** ~~2~~00 *1* 2.0

Required Date: 11/16/12 **Req'd Qty:** 1.00 *1*

Reference: **Cust Item ID:** **Customer:**

Approvals: **Process Plan:** ✓ **Date:** **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3294	~~pdf~~ Rev D 12/12/04								
100		0.00							
100						2	0		JM 12-11-15
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3294								
2024 .080	CUt File D3294-3b								
	Dwg Rev: P01								
	Prog Rev: P01								
	*grain direction on a 45 deg as per dwg**								
	2-Deburr if necessary								
110	QC2- inspect parts off machine FAI/FAIB	0.00							
110						2	0		JM 12-11-15
QC	**Memo**	0.00							
Quality Control									

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 93450

93450

November-15-12 8:37:10 AM

Item ID: D3294-1B **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: PRELIM **Stop** *NS2*
Item Name: Bracket, Blank

Start Date: 11/15/12 **Start Qty:** 1.00 *1*
Required Date: 11/16/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 15 2-89				2			
120									
QC	**Memo**	0.00 12/11/15				inspect as per Dwg pd 1			
Quality Control									
130		0.00							SB 12/11/15
130						2			
Brake NC	**Memo**	0.00							
Brake NC	1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)								
140	QC5- Inspect part completeness to step on W/O	0.00 DAS 15 2-89				2			
140									
QC	**Memo**	0.00 12/11/15				inspect as per Dwg pd 1			
Quality Control									

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric to O/S
☐	Cracks
☐	Crushed/Crimped
☐	Cuffs
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Ripples in Bend
☐	Torque Waves in Extrusion
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damaged
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drill Holes
☐	Drawing
☐	Finish
☐	Folio

☐	Grain
☐	Hardware
☐	Inspection Incomplete
☐	Instructions Incomplete/Unclear
☐	Maintenance
☐	Mislabeled
☐	Misread
☐	Offset
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions

☐	Ovalized
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge

☐	Pressure/Forced
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

Work Order ID 93450

93450

November-15-12 8:37:10 AM

Item ID: D3294-1B
Revision ID: PRELIM
Item Name: Bracket, Blank

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 11/15/12 **Start Qty:** 1.00 *1*
Required Date: 11/16/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				2		12-11-15	
150									
HandFinish	**Memo**	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00				2x			12/11/15
160									
QC	**Memo**	0.00							
Quality Control									
170		0.00				2x			12/11/15
170									
Small Fab	**Memo**	0.00							
Small Fab	1-Install D3294-5 doubler to D3294-3b bracket with rivets as per dwg. D3294								

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 93450

November-15-12 8:37:10 AM

93450

Item ID: D3294-1B
Revision ID: PRELIM
Item Name: Bracket, Blank

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 11/15/12 **Start Qty:** 1.00 *1*
Required Date: 11/16/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00 DAS 15 8-89				2			
180 QC Quality Control	**Memo**	0.00 12/11-15							
190	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				2X0			MA
190 Powdercoat Powder Coating	**Memo** Start Time: 7:30 Oven Temperature: 320°F Finish Time: 8:00	0.00							12/11/16
M121279									
200	QC3- Inspect Part Finish	0.00				2			12-11-16 DAS 16 8-89
200 QC Quality Control	**Memo**	0.00							

Inspected to PD Dwg. only DAS 16 8-89 12/11/16 x2

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D3294-1B **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: PRELIM **Stop** *NS2*
Item Name: Bracket, Blank

Start Date: 11/15/12 **Start Qty:** 1.00 *1*
Required Date: 11/16/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: SJ225	0.00							
210									
Packaging	**Memo**	0.00							
Packaging									

1 x BG3514

DAS 20 12-05

220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	**Memo**	0.00							
Quality Control									

12/12/14 MF 12-11-16

POSITIVE RECALL
EFFECTIVE 11 AUTH 12.11.15
RELEASED DAS 16 DATE 12/12/14
to Rev B Dwg.

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

November-15-12 8:37:10 AM

Work Order ID: 93450
Parent Item: D3294-1B
Parent Item Name: Bracket, Blank
Start Date: 11/15/12 **Required Date:** 11/16/12
Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 12.11.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3294-5 Doubler		Manufactured	No			170	Each	28.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				GA		28							
					76993	4							
					90097	24							
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	297.1700	0.18	~~0.1894737~~ 0.2			
				Location		**Loc Qty**		**Loc Code**					
				MAT022		297.17							
					105411	6							
					109424	4							
					112331	3							
					113796	5							
					114025	1.7							
					117392	19.1							
					118180	27							
					119117	23.7							
					120989	39.67							
					123217	168				123217			
MS20470AD4-5 Rivet, Universal Head		Purchased	No			170	Each	1,332.0000	15	15			
				Location		**Loc Qty**		**Loc Code**					
				334		1282							
					122452	1282				30			
				ST319		50							
					120142	50							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

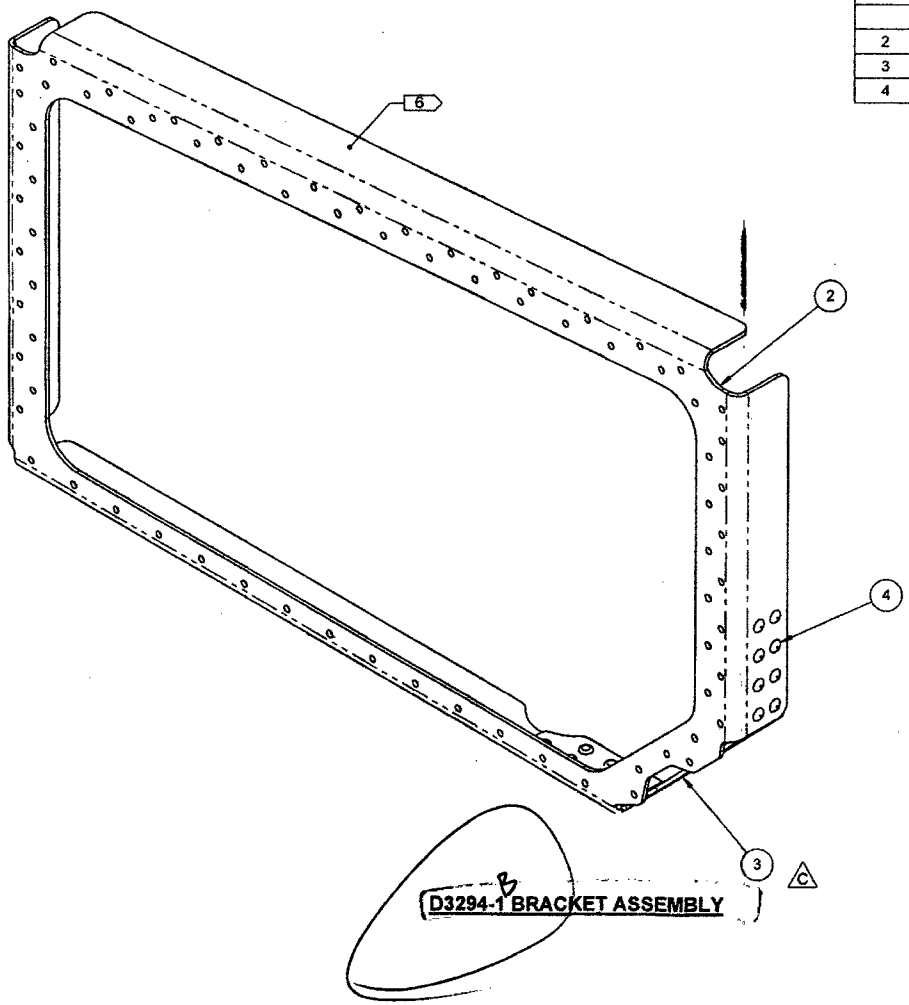
Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1 B	BRACKET ASSEMBLY
2	1	D3294-3 B	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



D3294-1 B BRACKET ASSEMBLY

dlo 93456

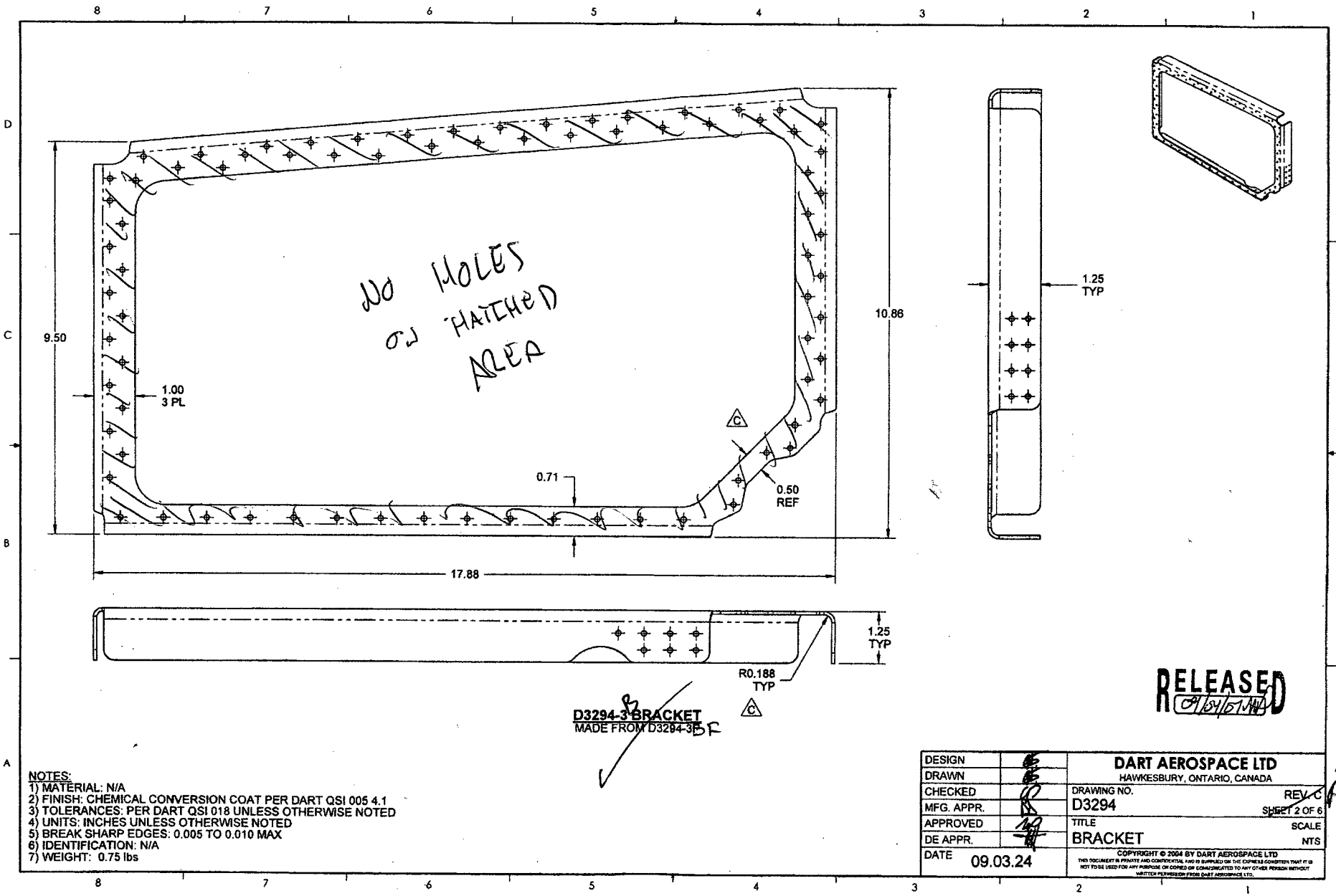
RELEASED 09/04/07 JWT

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.83 lbs

REV.	DESCRIPTION	BY	DATE
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.		09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.26

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. C
MFG. APPR.		SHEET 1 OF 6
APPROVED		TITLE BRACKET
DE APPR.		SCALE NTS
DATE 09.03.24		

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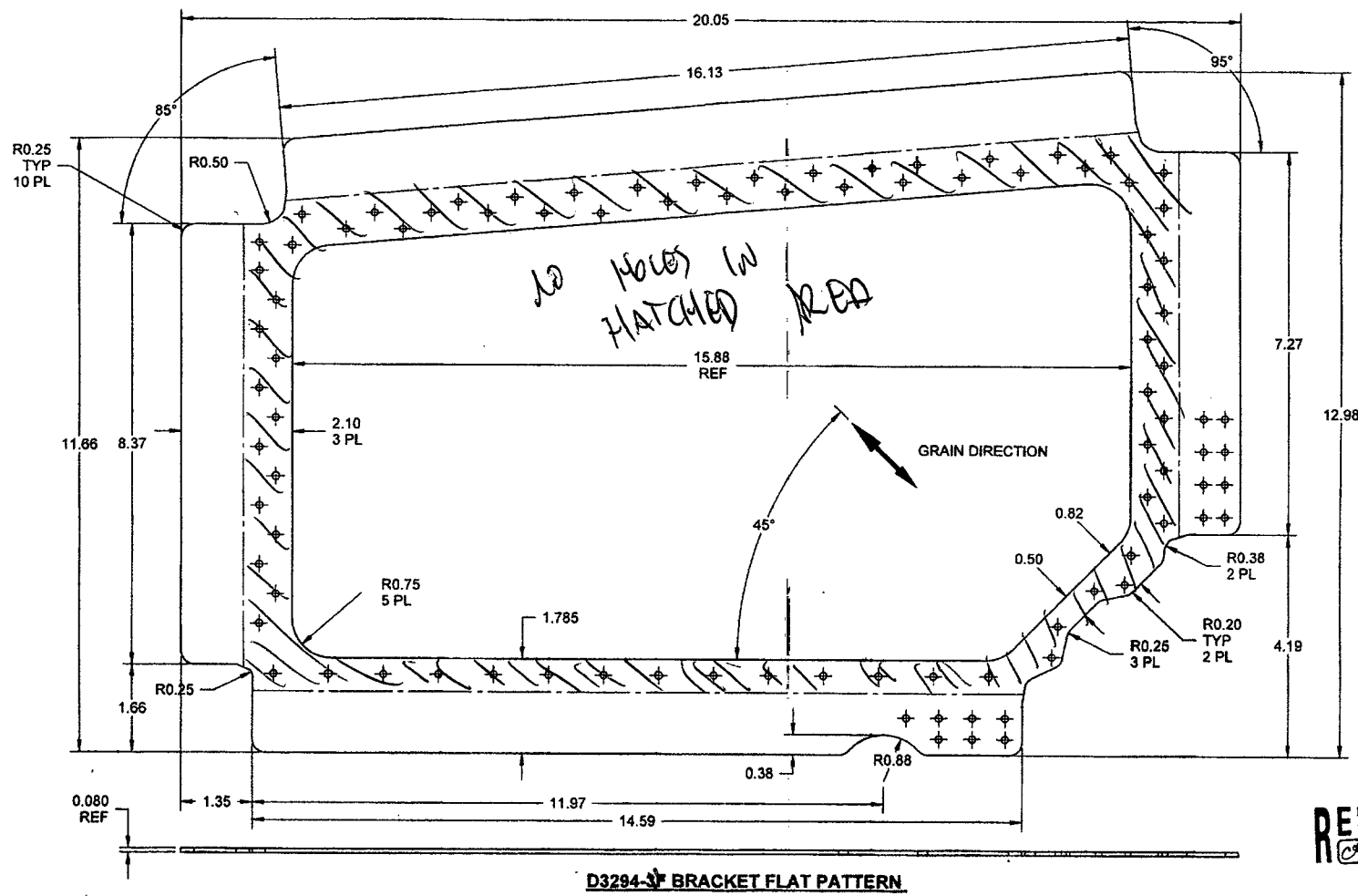
D3294-3 BRACKET
MADE FROM D3294-3 BF

RELEASED 09/04/24

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3294 REV. C
MFG. APPR.		SHEET 2 OF 6
APPROVED		TITLE BRACKET
DE APPR.		SCALE NTS
DATE 09.03.24		

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RELEASED
09/04/67

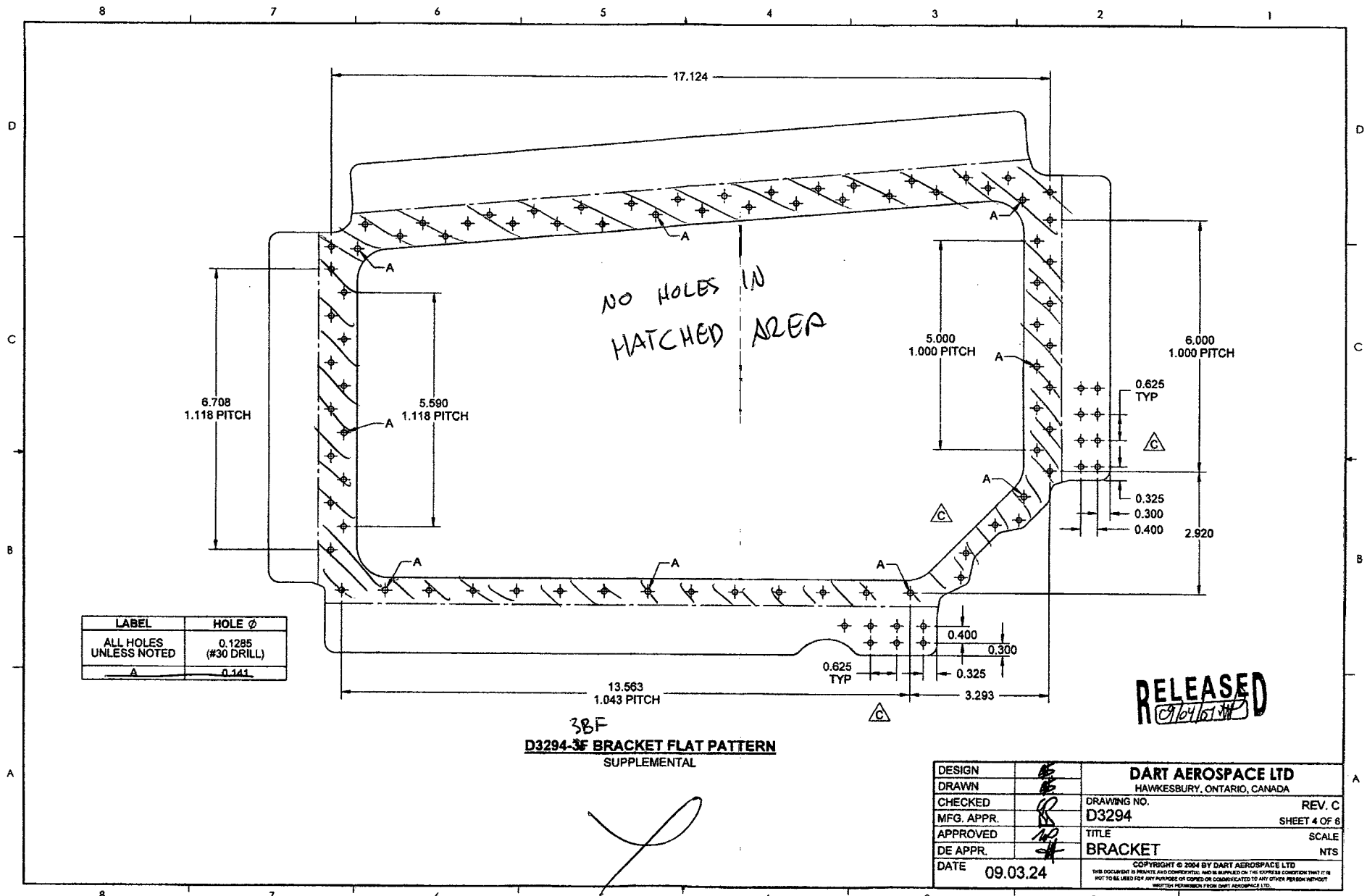
D3294-3F BRACKET FLAT PATTERN

3BF

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4
OR AMS 4037 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3294 REV. C
MFG. APPR.		SHEET 3 OF 6
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 09.03.24		

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LABEL	HOLE ∅
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

3BF

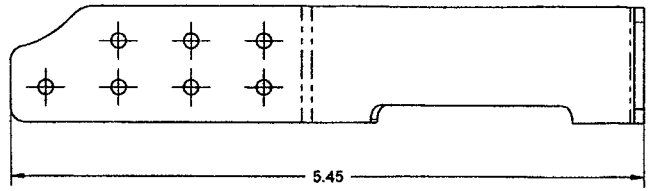
D3294-~~3F~~ BRACKET FLAT PATTERN

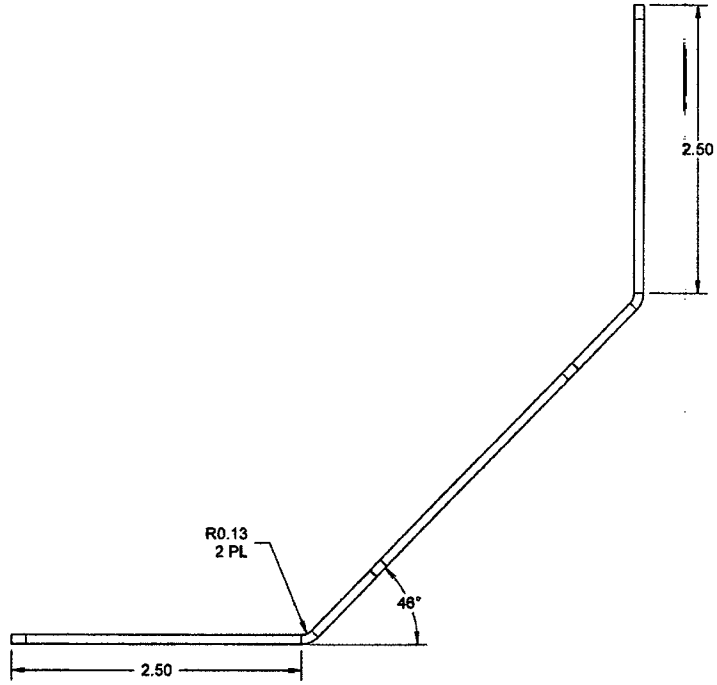
SUPPLEMENTAL

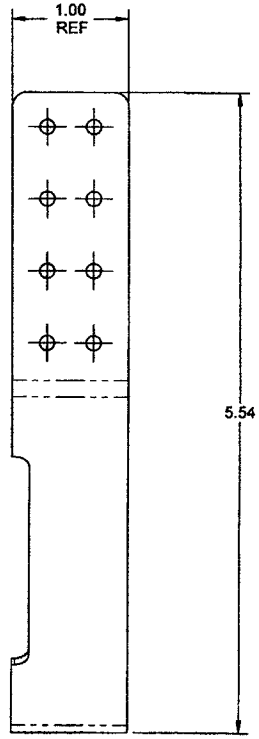
RELEASED 09/04/24

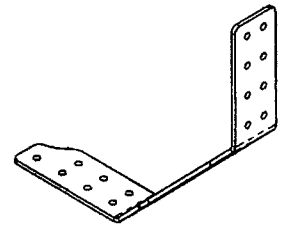
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. C
MFG. APPR.		SHEET 4 OF 6
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 09.03.24		

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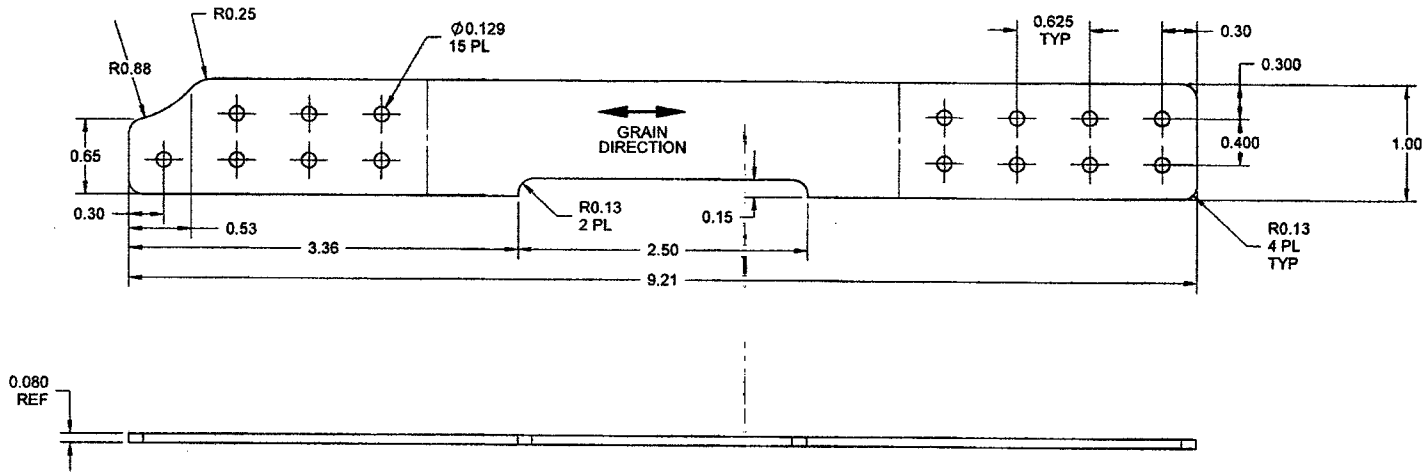
RELEASED
9/04/01 AP

D3294-5 DOUBLER
MADE FROM D3294-5F △C

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. C
MFG. APPR.		SHEET 5 OF 6
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 09.03.24		

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D3294-5F DOUBLER FLAT PATTERN △G

RELEASED
09/04/07

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4
OR AMS 4037 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. C
MFG. APPR.		SHEET 6 OF 6
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 09.03.24		

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DART AEROSPACE LTD		Work Order:	93450
Description: Bracket Assembly		Part Number:	D3294-136
Inspection Dwg: D3294	Rev: E 001		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131"	–		V	Probe502
~~Ø0.141~~	~~+0.005/-0.001~~				~~V~~	
~~6.708~~	~~+/-0.010~~					
~~1.118~~	~~+/-0.010~~					
~~5.590~~	~~+/-0.010~~					
~~1.118~~	~~+/-0.010~~					
~~13.563~~	~~+/-0.010~~					
~~1.043~~	~~+/-0.010~~					
✓ 0.625	+/-0.010	0.624"	–		V	
✓ 0.325	+/-0.010	0.323"	–		V	
✓ 0.300	+/-0.010	0.302"	–		V	
✓ 0.400	+/-0.010	0.395"	–		V	
~~6.000~~	~~+/-0.010~~					
~~1.000~~	~~+/-0.010~~					
~~17.124~~	~~+/-0.010~~					
✓ 16.13	+/-0.030	16.13"	–	–	T	
✓ 7.27	+/-0.030	7.269"	–		V	
✓ 11.97	+/-0.030	11.97"	–		V	
✓ 8.37	+/-0.030	8.363"	–		V	
✓ 20.05	+/-0.030	20.05"	–		T	
✓ 12.98	+/-0.030	12.98"	–		T	
✓ 14.59	+/-0.030	14.59"	–		T	
✓ 11.66	+/-0.030	11.666"	–		V	
✓ 0.080	+/-0.010	0.081"	–		V	

Measured by:	JM
Date:	12-11-15

Audited by:	DAS 15
Date:	12/11/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

Receiving Report

Date: 12/10/3

Batch No: M/12-3210

Supplier: Thyssenkrupp

Dart P/O: 17969

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ✓
Receipt: Cash ___ Cr ✓

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ___ No ✓
Shipment Complete: Yes ✓ No ___ N/A ___
QC6 Inspection DA ✓ N/A ___
Work Order 16 Mtdg N/A ✓

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 ✓

Production/Admin: Date Received/Costing Initial 12/10/3 ✓

Location ___

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Purchase Order Receipt Listing

Wednesday, October 03, 2012 7:08:26 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO17959 Receipt Dates from 10/3/2012 to 10/3/2012 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		**VC-COP001**	**Thyssenkrupp Materials CA Ltd**								
PO17959	3		M2024T3S.040	sf	9/26/2012	10/3/2012	192.0000	$4.28	0.0000	0	$821.90
CAD	No		2024-T3 .040 sheet 123217	sf	192.0000	DESJ02		$821.90	0.0000	0	
	4		M2024T3S.080	sf	10/3/2012	10/3/2012	192.0000	$6.93	0.0000	0	$1,330.37
	No		2024-T3 .080 sheet 123217	sf	192.0000	DESJ02		$1,330.37	0.0000	0	

Total Received Quantity:	384.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	$2,152.26
Total Balance Due Quantity:	0.0000

B I L L O F L A D I N G

No: PEC 787590

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship Date 27Sep12 at 14:51 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

==========

B I L L O F L A D I N G

MTR'S

1) Our Order PEC-492003- 1 Your PO # 17959
ALUMINUM SHEET 2024 -T3
.0400 Nom X 48.0000" X 144.0000"

Heat Number	Tag No	Quantity	PCS	Wt LBS
183665	108276	192.00 SFT	4	111

2) Our Order PEC-492003- 2 Your PO # 17959
ALUMINUM SHEET 2024 -T3
.0800 Nom X 48.0000" X 144.0000"

Heat Number	Tag No	Quantity	PCS	Wt LBS
717742	537429	192.00 SFT	4	221

	Tags	PCS	LBS
TOTAL:	2	8	332

ADD ON TO 491969 VIM /491972 SUR-CHARGE PAID

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.
ATTN: CHANTAL/LINDA
** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **
TOTAL 1 CUSH 1 SKID G.W 552 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

Page: 1 Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.
RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

TVQ/GST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

(2)

CERTIFIED INSPECTION REPORT

Alcoa Inc. DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

we hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious , or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

Ship From: RIVERDALE, IA.

Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	
1307952	0			
2011-11-07	6475671	00000	1000305977-1	DS-05977-02-1
P.O. No./Govt Contract No.	Customer		Alcoa Item	

Page 1 of 2

Ship To:

Charleston Aluminum LLC
489 Frontage Rd
Gaston, SC 29053

Item Description
0.08 IN TK (+.0035 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) CAT X 05315 (N) A/T 2024-T3 FLAT SHEET MILL PINISH. AMS-QQ-A-250/4
REV A IS 2010 EXC_MRK AMS4037 REV N IS 2008
EXC_MRK ASTMB209 REV 07 ((MARKED)) KRAFT PAPER INTERLEAVED MAX
GROSS SKID WGT: 4750 LB QUAN TOL +/-20 %
CQR D126159 REV 29 CUST REQ 11-11-07 *** W/E 11-11-12 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	340227	717741	790	14	PC	27695 47349
2	340227	717742	3221	57	PC	27695 47349
			4011	71		

Notes for CQR: D126159.29
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ- A-250/4 ALSO MEETS THE REQUIRREMENTS OF QQ-A-250/4E, AMENDM ENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS -QQ-A-250/4.

CQR: D126159.29 -Specification Limits

Tmpr	Dir		UTS KSI	TYS KSI	EL4D PCT
T3	Long Transv.	Max			
		Min	63.0	42.0	15

TW METALS
TEST REPORTS
NOV 09 2011
JL
ACCEPTED BY

From: Copper and Brass Sales
Cust: THYSSENKRUPP MATERIALS NA - ECAD Del: 2402072311
Part: PO: IEC# 242215
Wgt: 221.184 LB Date: (9/20/2012

James Baker

CERTIFIED INSPECTION REPORT

Alcoa Inc DAVENPORT WORKS [illegible]

...applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Per

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thare
Quality Assurance Manager

1307952	0		Ship From: RIVERDALE, IA.	
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	
2011-11-07	6675671	00000	1000305977-1	DS-05977-02-1
P.O. No./Govt Contract No.	Customer		Alcoa Item	

CQR: D126159.29 -Specification Limits (cont.) ----------

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 2024	Max	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.15	
	Min			3.8	0.30	1.2						REMAIN

Lot: 717741 - Mechanical, Physical, Metallography, Quantometer Results ----------

Tmpr	Dir	No->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T3	Long Transv.	5	64.4	44.9	19
			64.1	45	18.5
			63.7	44.5	17.7
			64.3	44.8	18.4
			64.3	44.6	18.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9962033	Actuals	0.06	0.16	4.6	0.65	1.5	0.00	0.08	0.03

Lot: 717742 - Mechanical, Physical, Metallography, Quantometer Results ----------

Tmpr	Dir	No->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T3	Long Transv.	5	64.5	44.1	18.8
			64.8	44.3	20
			64	43.5	19.2
			64.3	44.3	18.6
			64.3	44.6	

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9964015	Actuals	0.06	0.13	4.6	0.63	1.5	0.00	0.04	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

TW METALS TEST REPORTS
NOV 09 2011
JL
ACCEPTED BY

From: Copper and Brass Sales
Cust: THYSSENKRUPP MATERIALS NA - ECAD Del: 2402072311
PO: PEC# 242215
Part:
Wgt: 221.184 LB
Date: 09/20/2012

James L Baker

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17959

Purchase Order Date 9/20/12
PO Print Date 9/20/12

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	905 669 9444	**Requisition Nbr**	
Vendor Fax	905 738 9033	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: MATERIAL: 2024-T3 ALUMINUM SHEET
QQ-A-250/4 OR AMS-QQ-A-250/4 OR
AMS 4037
OR ASTM B209

4	M2024T3S.080	2024-T3 .080 sheet	10/03/12 Yes	192.00 sf	Yours ppd	$6.8125	$1,308.00

Special Inst: MATERIAL: 2024-T3 ALUMINUM SHEET
QQ-A-250/4 OR AMS-QQ-A-250/4 OR
AMS 4037
OR ASTM B209

12/6/13

PO Total: $4,589.88

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - (YES) NO

Change Nbr: 1 **Change Date:** 9/20/12

DART AEROSPACE LTD		Work Order:	B93450
Description:	Bracket Blank	Part Number:	D3294-1B
Inspection Dwg:	D3294-3 Rev:	Pd 1	Page 1 of 1

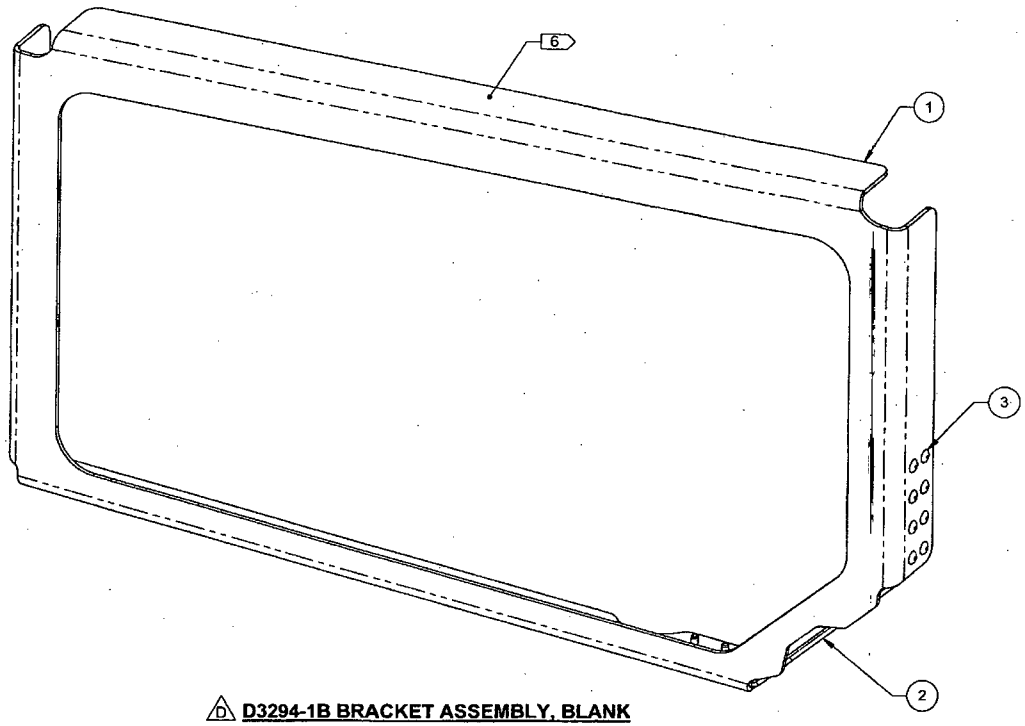
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.59	± 0.030	9.50	✓		J	
1.06	± 0.030	1.033	✓		J	
17.88	± 0.030	17.95	✓		J	
071	± 0.030	0.695	✓		J	
0.50	± 0.030	0.504	✓		J	
10.88	± 0.030	10.90	✓		J	
R0.188	± 0.010	.188	✓		S	
1.25 TYP	± 0.030	1.288	✓		J	

Measured by:	DAS SM 12.15.15	Audited by:	DAS 16 12/14/15	Preliminary Approval:	
Date:	12.11.15	Date:		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

ITEM	QTY -1B	P/N	DESCRIPTION
	X	D3294-1B	BRACKET ASSEMBLY, BLANK
1	1	D3294-3B	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



△D **D3294-1B BRACKET ASSEMBLY, BLANK**

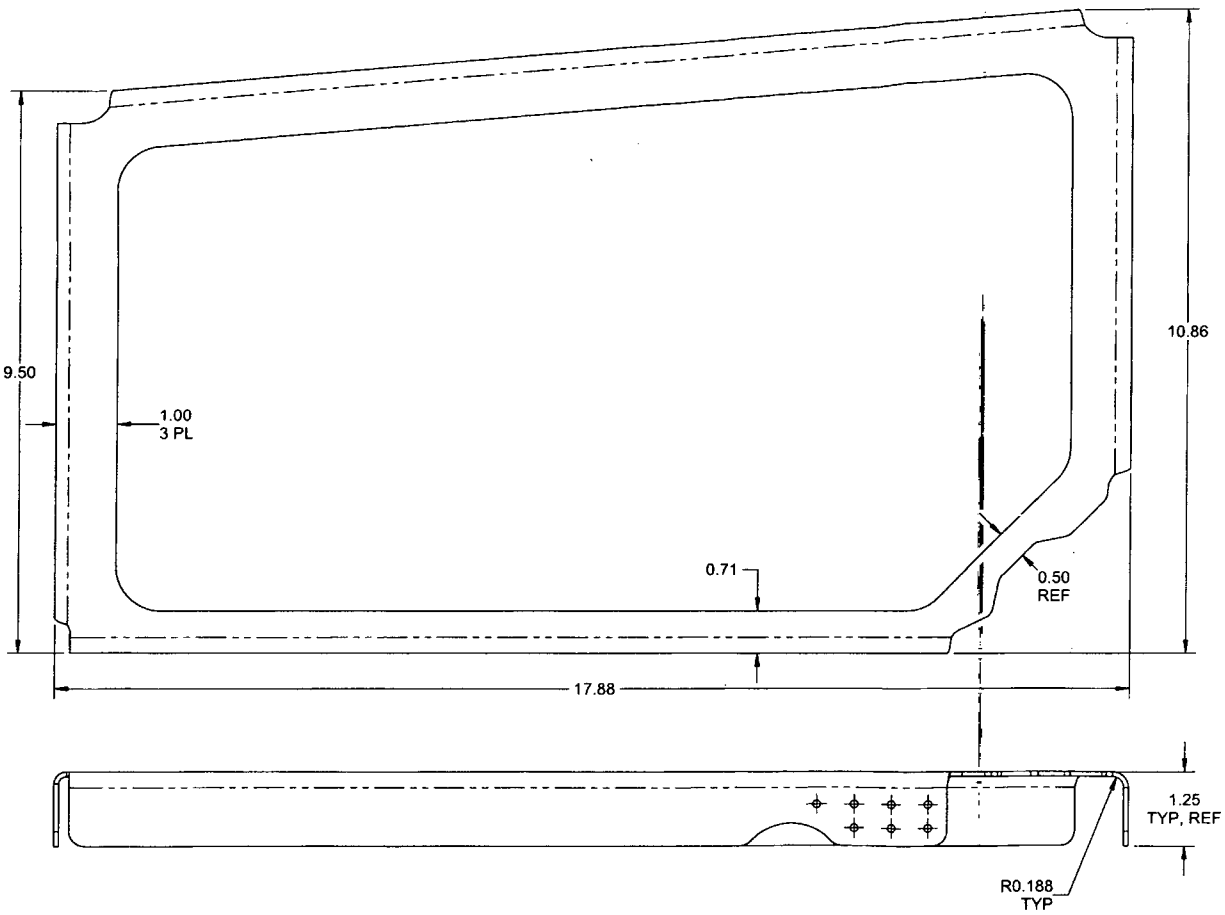
93450

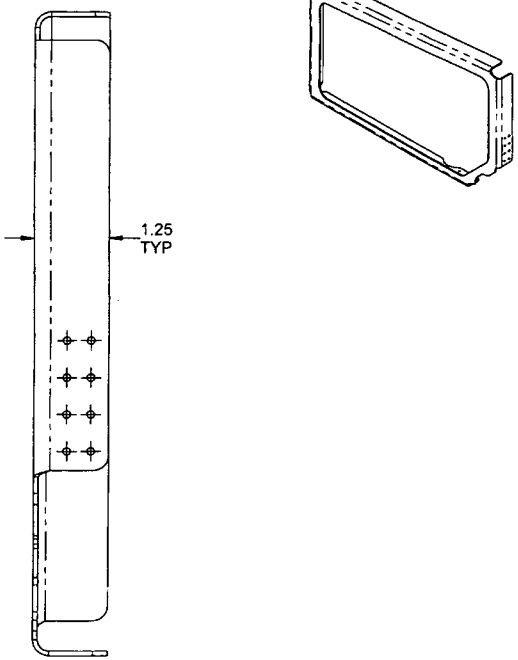
RELEASED
2012 -11- 21

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1B" PER DART QSI 044 6.1
7) WEIGHT: 0.83 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. D
MFG. APPR.		SHEET 2 OF 9
APPROVED		TITLE BRACKET
DE APPR.		SCALE NTS
DATE	12.11.15	

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D3294-3B BRACKET
(D) MADE FROM D3294-3BF

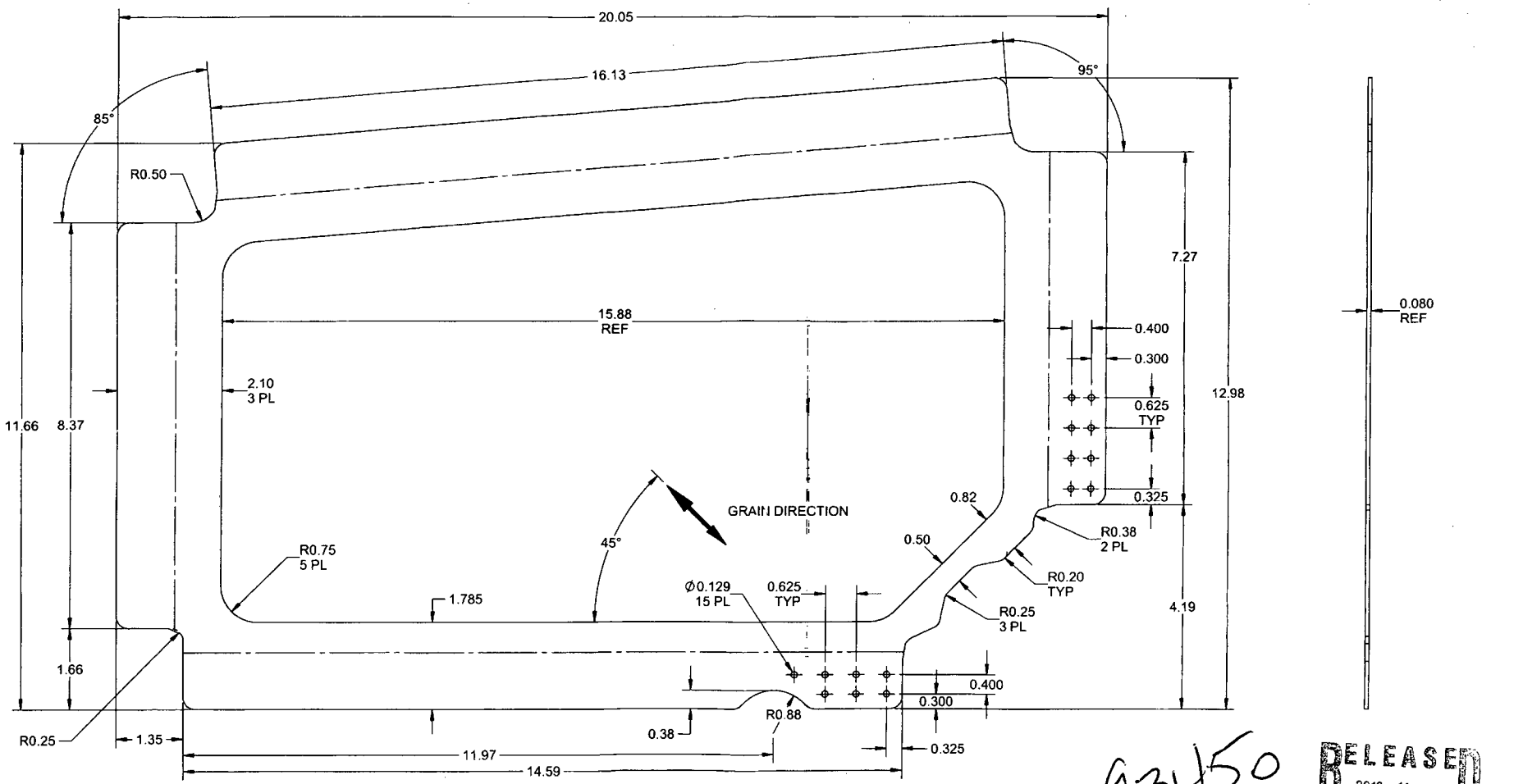
RELEASED
2012 -11- 21

93450

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT OER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.76 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 — REV. D
MFG. APPR.		SHEET 4 OF 9
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE 12.11.15		

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△D **D3294-3BF BRACKET FLAT PATTERN, BLANK**

93450 RELEASED 2012-11-21

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. D
MFG. APPR.		SHEET 7 OF 9
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 12.11.15		

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